

SHIP JULY 3

Work Order ID 134112

134112

Page 1

Item ID: DSI 9585-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lock Barrel Spring Replacemet

Start Date: 7/02/15

Start Qty: 20.00

20

Cust Item ID:

Required Date: 7/03/15

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

157002

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9585	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI 9585-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

JUL 03 2015

DAS
6
9-89DAS
27
9-89

JUL 02 2015

DAS
26
9-89

JUL 03 2015

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 134112

Thursday, July 02, 2015 9:48:35 AM

134112

Page 2

Item ID: DSI 9585-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock Barrel Spring Replacemet

Start Date: 7/02/15 Start Qty: 20.00

20

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									DAS
Packaging	Memo	0.00							6
Packaging	Identify and pack for shipping as per PPP DSI9585-013								9-09
	Location: <u>Ship</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

20x JUL 03 2015

MWS JUL 03 2015

MWS JUL 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Picklist Print

Thursday, July 02, 2015 9:48:39 AM

Page 1

Work Order ID: 134112

134112

Parent Item: DSI 9585-013

DSI 9585-013

Parent Item Name: Lock Barrel Spring Replacemet

Start Date: 7/02/15

Required Date: 7/03/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.01.11 new issue DD verf: JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4518-3

Manufactured

No

110

Each

47.0000

1

20

D4518-3

Lock Barrel Spring

DAS
6
8-88

Location

Loc Qty

Loc Code

ST112

47

125462

47

20

MS39086-133

Purchased

No

110

Each

213.0000

1

20

MS39086-133

Coiled Spring Pin

DAS
6
8-88

Location

Loc Qty

Loc Code

ST274

213

120298

213

20

DAS
6
8-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D, D350-589 REV. E,
IIN-D350-600 REV. E, AND IIN-D130-780 REV. B AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D350-588 REV. 0, ICA-D350-589 REV. 1, ICA-D350-600 REV. 5,
AND ICA-D130-780 REV. 1

REF CANADIAN STC: SH92-41, SH93-88
REF FAA STC: SH1012NE, SR00098NY, SR00099NY
AUSTRIAN STC: ACG.21NE2.093
REF EASA STC: EASA.IM.R.S.01292

PURPOSE:

The purpose of this DSI (Dart Service Instruction) is to introduce DSI 9585-011 and DSI 9585-013 Latch Repair Kits for D2586 Latches whose springs have failed or have been lost in service. Replacement procedures are as follows:

PROCEDURE:

TORSION SPRING REPLACEMENT (DSI 9585-011 KIT):

- 1) Remove D2586 Latch by unfastening the MS27039-1-XX Screw and associated hardware. Retain all hardware/parts.
- 2) Remove and discard roll pin with adequate tool. Discard existing failed spring.
- 3) Install D4518-1 Torsion Spring by inserting provided MS39086-133 Coiled Spring Pin in place using adequate tool. Refer to Figure 1 of this service instruction.
- 4) Reinstall repaired D2586 Latch in accordance with respective STC using the hardware/parts removed at Step 1 above.

LOCK BARREL SPRING REPLACEMENT (DSI 9585-013 KIT):

- 1) Remove D2586 Latch by unfastening the MS27039-1-XX Screw and associated hardware. Retain all hardware/parts.
- 2) Remove and discard roll pin with adequate tool. Discard existing failed spring.
- 3) Install D4518-3 Lock Barrel Spring by inserting provided MS39086-133 Coiled Spring Pin in place using adequate tool. Refer to Figure 2 of this service instruction.
- 4) Reinstall repaired D2586 Latch in accordance with respective STC using the hardware/parts removed at Step 1 above.

PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9585-011	TORSION SPRING REPLACEMENT KIT
	X	DSI 9585-013	LOCK BARREL SPRING REPLACEMENT KIT
1		D4518-1	TORSION SPRING
	1	D4518-3	LOCK BARREL SPRING
1	1	MS39086-133	COILED SPRING PIN

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE:

CERT. NO.: SH92-41/SH93-88

ISSUE NO.: 8/6

A	NEW ISSUE	(REF. PAR11-135)	MB	11.12.05
REV.	DESCRIPTION		BY	DATE
DESIGN	B		DART AEROSPACE LTD	
DRAWN	B		HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q		DRAWING NO. REV. A	
MFG. APPR.	N/A		DSI 9585 SHEET 1 OF 2	
APPROVED	H		TITLE SCALE	
DE APPR.	H		LATCH REPAIR KIT NTS	
DATE	11.12.05		COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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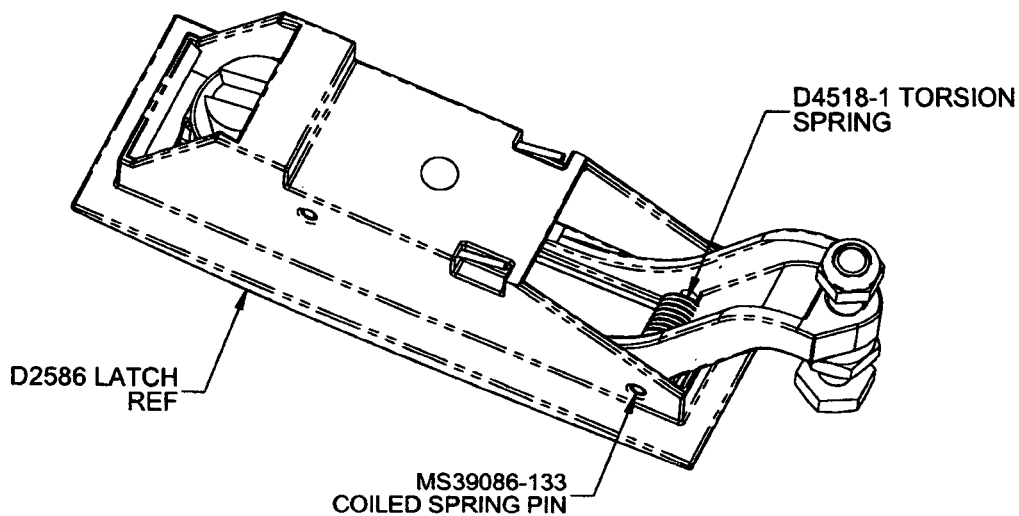


FIGURE 1: TORSION SPRING REPLACEMENT (DSI 9585-011)

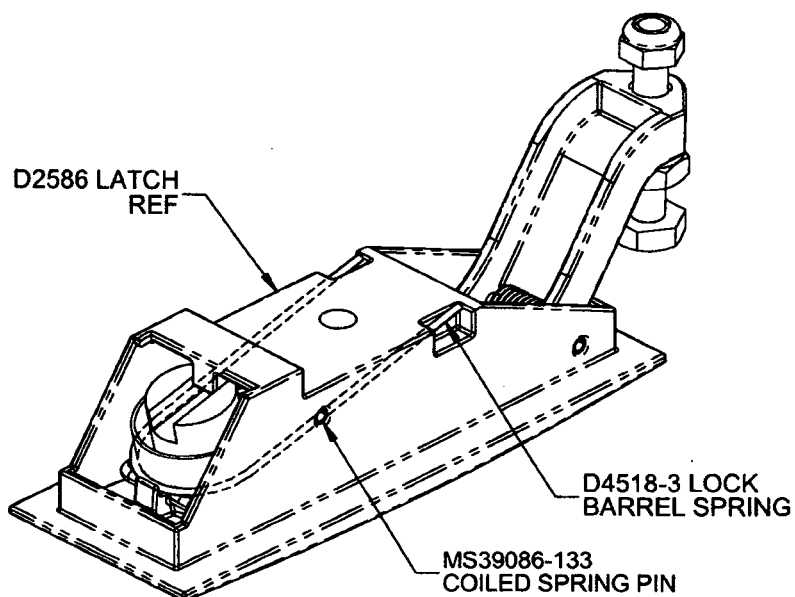


FIGURE 2: LOCK BARREL SPRING REPLACEMENT (DSI 9585-013)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: _____
CERT. NO.: SH92-41/SH93-88
ISSUE NO.: 8/6

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9585	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LATCH REPAIR KIT	NTS
DATE	11.12.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	